: FWD ADJUSTABLE BLADE SUPPORT ASSY

User:

Toursday, 24/07/2008 8:20:48 AM

Melanie Fauteux

**Process Sheet** 

**Drawing Name** 

: CU-DAR001 Dart Helicopters Services Customer

S.O. No. :

Type

: 40606 -2 Job Number Estimate Number : 13435

P.O. Number

: 24/07/2008 This Issue

: NC Prsht Rev.

: 17/07/2008 First Issue

**Previous Run** 

Written By

Checked & Approved By

: Est Rev:A

08-06-26 new issue DD verified by:ec

: LARGE FAB ASSY

**Additional Product** 

Job Number:

Seq. #:

Machine Or Operation:

Inner Tube

Inner Tube Bushing

5.0000 Each(s)

5.0000 Each(s)

Gusset

5.0000 Each(s)

Gusset

5.0000 Each(s)

PB67-43001-67

5.0000 Each(s)

Total:

Description:

1.0 PB6743001247

Comment: Qty.: 1.0000 Each(s)/Unit Total:

Inner Tube

Comment: Qty.:

1.0000 Each(s)/Unit Total:

Inner Tube Bushing

batch: MHO19

3.0

Comment: Qty.:

1.0000 Each(s)/Unit Total: Gusset

4.0

Comment: Qty.: 1.0000 Each(s)/Unit

PB67430016 5.0

Comment: Qty.: 1.0000 Each(s)/Unit Total:

: PB674300111 Part Number

: B6743001 P.8 **Drawing Number** 

: N/A Project Number : B1 **Drawing Revision** 

Material

: 24/07/2008 **Due Date** 

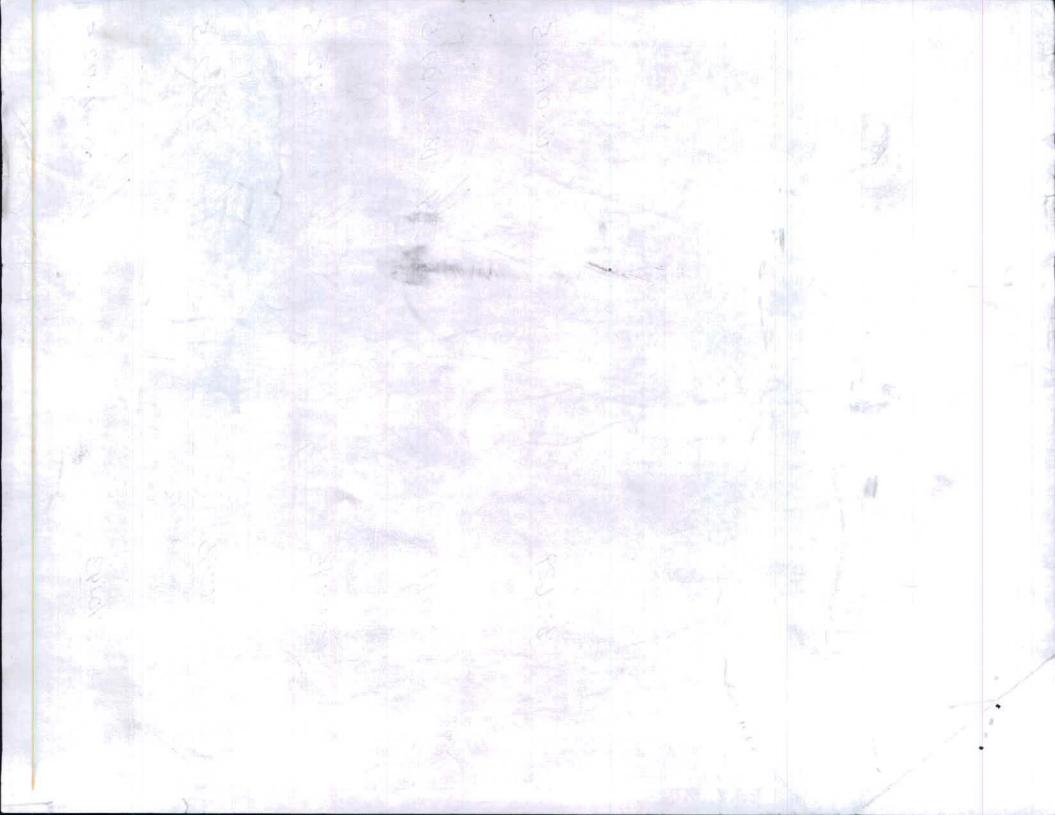
Qty:

5 Um:

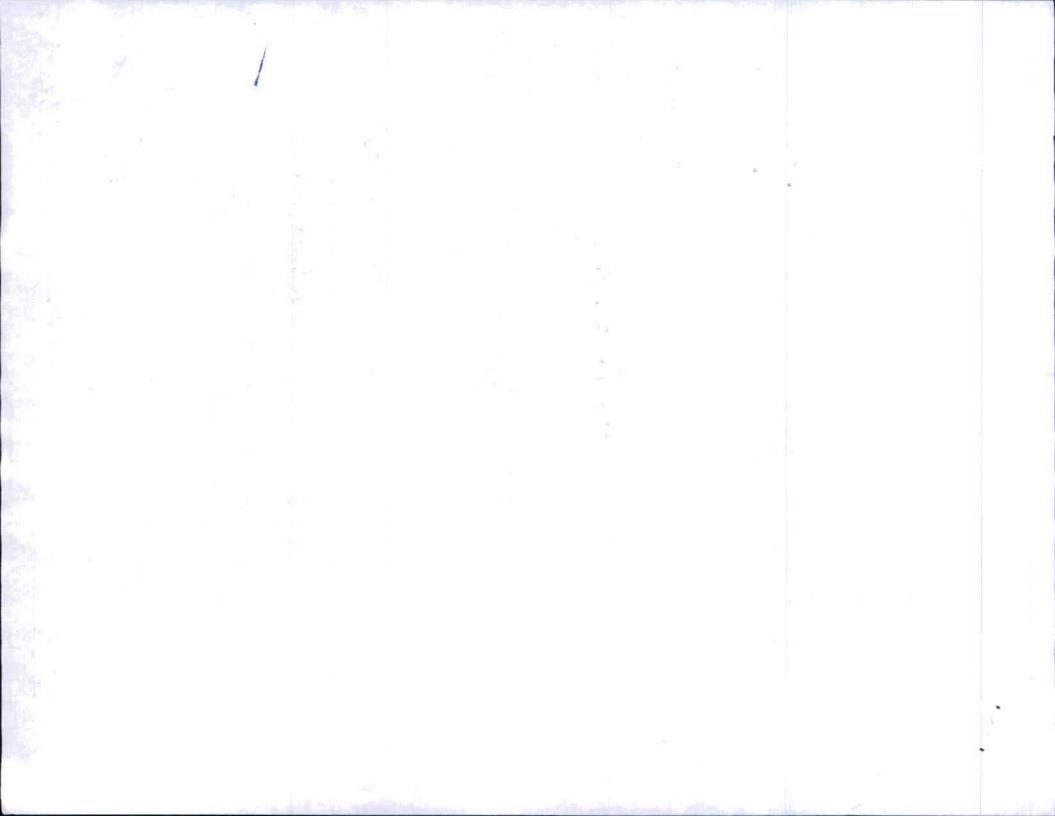
raplicate

Each

08-01.225



Date: Thursday, 24/07/2008 8:20:48 AM User: Melanie Fauteux **Process Sheet** • Customer: CU-DAR001 Dart Helicopters Services Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY Joh Number: 40606 Part Number: PB674300111 Job Number: Seq. #: Machine Or Operation: Description: 6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg VISUAL WELDING INSPECTION 7.0 QC9 Comment: VISUAL WELDING INSPECTION 8.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP MS124780 HELICAL INSERT Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) HELICAL INSERT 10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 2- tap drill for helicol 3- install helicol insert as per dwg 11.0 QC5 INSPECT WORK TO CURRENT STE Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE # Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 13.0 102316 Comment: POWDER COATING BR 08-07-31 1- MASK TUBE FROM BASE TO GUSSET 2- Powder Coat Green Sandtex (Ref. 4.3.5.8) as per QSI 005 4.3



Thursday, 24/07/2008 8:20:48 AM Date: Melanie Fauteux User: **Process Sheet** Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services Part Number: PB674300111 Job Number: 40606 Jeb Number: Seq. #: Machine Or Operation: Description: =30 START TIME: OVEN TEMPERATURE: FINISH TIME: 14.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PB674300169 90 Degree Cover Plate Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) 90 Degree Cover Plate 08.08-26 batch: PB674300183 PB67-43001-83 16.0 Comment: Qty.: 5.0000 Each(s) 1.0000 Each(s)/Unit Total: PB67-43001-83 batch: 17.0 MS27039110 Screw Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s) Screw 108.08.26 batch: NAS1149F0316F WASHER 18.0 Comment: Qty.: Total: 40.0000 Each(s) WASHER batch: 19.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 08.08.26 2- assemble as per dwg

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Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



21.0

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



08/08/26 h 08.08 26

	1

